Work Order ID 68202



Page 1

Friday, April 08, 2011 10:37:49 AM D3219-1 Item ID: **Revision ID:**

Required Date: 4/12/2011

Accept



Setup Start



Stop

Item Name: **Start Date:**

Plate

4/8/2011

QC:

Start Qty: 30.00

Req'd Qty: 30.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date: 1/04-8

Date:

Tooling:

Date:

Run

Start

Stop

 SPC (Y/N):	Da	ate:		510	'P		
Set Up/	Tool ID	Tool # Plan	Accept	Reject	Reject	Insp.	

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3219	Rev A									
Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as p Dwg Rev Prog Rev	per Dwg D3219	0.00				<u> 1811-</u>	<u>4-11</u>	(100)	
110 	QC2- Inspect parts off	machine FAI/FAIB	0.00				1311-	4-111	_	

Quality Control

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

2 worly

OSIDIS

W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										,
Part No	:	PAR #:	Fault Cate	egory:	NCF	l: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	on:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section B				Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	3	Sign & Date	Sect	tion C	Chief Eng	QC Inspector
			·							

Work Order ID 68202 Friday, April 08, 2011 10:37:49 AM

Page 2

Item ID:

D3219-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Plate Item Name:

4/8/2011

Start Qty: 30.00

Reg'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty



Required Date: 4/12/2011

QC:

Date:

SPC (Y/N):

Tool ID

Date:

Tool # Plan

Code

Stop

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

1-Deburr if necessary.

Set Up/ **Run Hours**

0.00

Accept

Qty

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Memo

150

Packaging

Packaging

Identify as per dwg & Stock Location:

*** STOCK IN STEP CELL***

0.00

0.00

M11.04.27

DATE STED PROCEDURE CHANGE By Date Oty Chiefford Approval	O:			V	ORK ORDER CHAI	NGES					
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:		STEP	PRO				Ву	Date	Qty	Chief Eng /	Approval QC Inspector
Part No:				***************************************	-					Frod Mgr	
Part No:											
Part No:									1		
Part No:				,							
			<i>4</i>								
						-					
Resolution: Disposition: QA: N/C Closed: Date:	art No:	o:	PAR #:	Fault Ca	tegory:	NCR	: Yes N	o DQA:		Date:	
	Res	Resolut	tion:	Disposit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	CR:			WORK OR	DER NON-CONFOR	RMANCE	(NCR)			<u> </u>	
DATE STEP Description of NC Corrective Action Section B Verification Approval Approval Approval	ATE STED	CTED	Description of NC					Verifica	ition	Approval	Approval
	AIE SIEP	SIEP	Section A		Action Description Chief Eng	on				Chief Eng	QC Inspector
					,						
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Work Order ID 68202 Friday, April 08, 2011 10:37:49 AM



Page 3

Item ID:

D3219-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 4/12/2011

Plate

4/8/2011

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

Operation

Description

Date:

SPC (Y/N):

Date:

Stop

Stop



Sequence ID/

Work Center ID

160

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 0.00

Tool ID

Tool # Plan

Code

Reject Accept Qty Qty

Reject Number Stamp

Insp.

Memo

0.00

Quality Control

	•								
W/O:			WC	RK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
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NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCR)			A CONTROL OF THE CONT
D.47F		Description of NC			tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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1	1	T. Control of the Con			1	1		1	1

Picklist Print

Friday, April 08, 2011 10:37:55 AM

Work Order ID: 68202

Parent Item:

D3219-1

Parent Item Name: Plate



Start Date: 4/8/2011

Required Date: 4/12/2011

Page 1

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP A□04.04.19□New issue□KJ/JLM□

ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No		100	sf	143.4000	0.0964	3.044211	6	5	
									1811-4	-11	_	

6061-T6 .125 Sheet

Location	Loc Oty	Loc Code		
MAT021	143.4			(ILA)
113608	119.4		113608	(100)
116700	24			

W/O:			V	ORK ORDER CHA	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					,			5		
Part No		PAR #:	Fault Ca	tegory:	NC	R: Yes I	No DQA		Date:	
	R	esolution:	Disposit	ion:	QA	N/C Clo	sed:		Date: _	
NCR:	-	V	VORK OR	DER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action	Section B	Sign &	Verific		Approval	Approval
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DART AEROSPACE LTD	Work Order:	48202
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	,317	be be		U ROZ	
2.293	+/-0.005	196.6	صلا		U	
2.965	+/-0.010	2967	%		V	
0.566	+/-0.010	,546	يو		V	
0.375	+/-0.010	:313	ـــــــــــــــــــــــــــــــــــــــ		V	-
R0.125	+/-0.010	1175	<u>ئ</u> د		R.G.	
13.9°	+/-0.5°	B.9°	<u>\</u>		V	
						-

Measured by:	Audited by: 👌	Prototype Approval:	N/A
Date: 11-4 - 11	Date: 11/04/0	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue	KJ/JLM	
В	07.09.06	13.9° dimension added	KJ/JLM ,	
С	08.04.15	0.125 dimension removed	KJ/DD ox	

	-									
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								,		
		-								
Part No:							DQA: Date:			
	R	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date:		
NCR:		\	WORK ORE	DER NON-CONFORMA	ANCE (NCF	l)				
DATE	STEP	Description of NC Section A		ion B	Verific	fication	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector	
							-			
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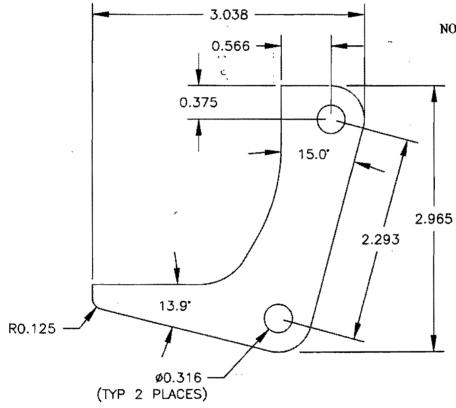




	DESIGN (DRAWN BY		AEROSPACE LTD WKESBURY, ONTARIO, CANADA
ı	CHECKED,	APPROVED,	DRAWING NO.	REV. A
	-#-	#-	D3219	SHEET 1 OF
ľ	DATE	<u> </u>	TITLE	SCALE
	03.10.10		PLATE	1:
T	Α	03,10,10	NEW ISSUE	

SHOPCUPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER NO_68202 Pl 11-04-8



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)

(REF DART SPEC M6061T6S.125)

- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cate	jory:	_ NCR:	Yes I	No DQ	A:	Date:			
	Re	solution:	Disposition:				sed:	Date:				
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)					
DATE	STEP	Description of NC Corrective Action Se			ion B	Verification		cation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector		
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